



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3210
Job Sheet 185760



Part No: 646.3210

Job Qty: 10 ea

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV n/c IPP REV:A NEW ISSUE 12-11-09 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Machining-1		lll
100	Bandsaw	10 pcs	11/23/18	11/23/18	0.00	0.36	Bandsaw1		lll
110	CNC Vertical Machining	10 pcs	11/23/18	11/23/18	0.32	21.69	HAAS1-1		lll
130	QC	10 pcs	11/23/18	11/23/18	0.00	0.00	QC8 Machining-1		lll
140	Outsource	10 pcs	11/23/18	11/23/18			ATG001-VC	5	lll
150	Packaging	10 pcs	11/23/18	11/23/18	0.00	0.00	Packaging2		lll
155	QC	10 pcs	11/23/18	11/23/18	0.00	0.00	QC5		lll
180	Packaging	10 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-1		lll
190	QC21-SA	10 Ea	11/23/18	11/23/18	0.00	0.00	QC21		lll

Part Op 100 - Cut Blank at 10.35"

Descriptions: 110 - 1-Machine per folio FB146

140 - Issue P/O to ATG 1- Hard Anodize Color Black and Prime as per Dwg 646.3200

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S6.000X1.000	7075-T6S Sheet 6" Thick Plate X 1" Wide	8.6600 ft (.866 ea)	90-Start up Operation	5129449

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S6.000X1.000	9	17	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	5.813Inches ± 0.005	5.818 5.808		
2	Support	0.250Inches ± 0.005	0.255 0.245	Radius	
3	Support	0.313Inches ± 0.005	0.318 0.308	Radius	
4	Support	0.110Inches ± 0.005	0.115 0.105		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

5	Support	0.875Inches $\pm$ 0.005	0.880 0.870	
6	Support	0.125Inches $\pm$ 0.005	0.130 0.120	
7	Support	0.063Inches $\pm$ 0.005	0.068 0.058	
8	Support	0.825Inches $\pm$ 0.005	0.830 0.820	
9	Support	3.526Inches $\pm$ 0.005	3.531 3.521	
10	Support	2.465Inches $\pm$ 0.005	2.470 2.460	
11	Support	4.728Inches $\pm$ 0.005	4.733 4.723	
12	Support	0.094Inches + 0.004 - 0.001	0.098 0.093	
13	Support	0.100Inches $\pm$ 0.005	0.105 0.095	
14	Support	0.125Inches $\pm$ 0.005	0.130 0.120	Radius

Plex 11/1/18 1:54 PM Dart.lajeunesse.marie



Container No: S131207



Part: 646.3210

Job No: 185760

Serial No/Batch: S131207

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/24/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	14.06.25	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041851**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: PO041851
PO Date: 11/26/18
Due Date: 12/11/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:

Attention: Lalande, Marc-Andre

Via: Ground
Pymt Terms: Net 30

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Freight Terms:
Special Comments: ** Please confirm dates as per line ** :)

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185269	RBW109-3130-70-101-7	Base -Issue P/O to ATG; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	12/4/18	4 pcs	0 pcs	4 pcs	\$11.00/pcs	\$44.00
4X NOV 27 2018											
Line Item Note ** ASAP **											
2	185760	646.3210	Support Issue P/O to ATG : 1- Hard Anodize Color Black and Prime as per Dwg 646.3200	Firmed	-	12/4/18	10 pcs	0 pcs	10 pcs	\$20.35/pcs	\$203.50
10X DEC 17 2018											
3	186020	649.5010	Deflector Issue P/O to ATG: HARD ANODIZE COLOR BLACK,AND PRIME AS PER DWG 649.5000 REV. D	Firmed	-	12/11/18	1 pcs	0 pcs	1 pcs	\$40.00/pcs	\$40.00
	186828			Firmed	-	12/11/18	1 pcs	0 pcs	1 pcs	\$40.00/pcs	\$40.00
Sub Total:							2	0	2		\$80.00



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041851**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	186019	649.5214	Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF- 23377 TYPE 1 CLASS N	Firmed	-	12/11/18	4 pcs	0 pcs	4 pcs	\$15.00/pcs	\$60.00
5	185271	RBW109- 3130-70- 101-5	Barrel -Issue P/O to ATG; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	12/11/18	5 pcs	0 pcs	5 pcs	\$11.00/pcs	\$55.00
Grand Total:											\$442.50

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/27/18 12:59 PM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916784

Date: 13-Dec-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 10 ea	Part: 646.3210 Support Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24219	Rev: NC PO: PO041851 Line: 2	
✓ 4 ea	Part: 649.5214 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24221	Rev: C PO: PO041851 Line: 5	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>13/12/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

Made in Canada.